

Date: Monday, 5/7/2007 3:26:13 PM  
 User: Kim Johnston

## Process Sheet

|   |                                      |
|---|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services      | Drawing Name : MID TUBE ASSEMBLY     |
| Job Number : 32237                                  |                                      |
| Estimate Number : 10469                             |                                      |
| P.O. Number : <i>N/A</i>                            | Part Number : D3391023               |
| This Issue : 5/7/2007 S.O. No. : <i>N/A</i>         | Drawing Number : D3391 REV F         |
| Prsht Rev. : NC                                     | Project Number : <i>N/A</i>          |
| First Issue : <i>N/A</i> Type : LANDING GEAR        | Drawing Revision : F                 |
| Previous Run : 32236                                | Material : <i>N/A</i>                |
| Written By : <i>[Signature]</i>                     | Due Date : 6/10/2007 Qty: 1 Um: Each |
| Checked & Approved By : <i>[Signature]</i> 07.05.07 |                                      |
| Comment : Est. A 05.10.20 New Issue KJ/EC           |                                      |
| Est. B 06.02.10 ECN773 dwg rev.D EC                 |                                      |
| est C 07.03.20 rev F dwg EC                         |                                      |
| est D 07.03.28 re-format EC                         |                                      |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | D25001100 | Skidtube Extrusion |
|-----|-----------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 SKIDTUBE EXTRUSION

Pick:

|     |             |             |                         |
|-----|-------------|-------------|-------------------------|
| Qty | Part Number | Description | Batch                   |
| 1   | D2500-1-100 | Extrusion   | <i>B24593 DP 7-5-10</i> |

|     |          |                   |
|-----|----------|-------------------|
| 2.0 | D3391021 | Fwd Tube Assembly |
|-----|----------|-------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Fwd Tube Assembly  
 Batch: *B31307*

|     |                |                         |
|-----|----------------|-------------------------|
| 3.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1  
 1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open float bag holes 0.257" as per Dwg D3391

5-C'sink float bag holes as per Dwg D3391

6-Open remaining holes to Ø0.375" except for fwd saddle hole of detail "J"

*DP 7-5-10*

| W/O: _____ |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE       | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|            |      |                    |    |      |     |                                     |                          |
|            |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 5/7/2007 3:26:13 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 32237

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

- 7-Remove .030" from Fwd indexing Ridge as per Dwg D3391
- 8-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391
- 9-Deburr
- 10-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,
- 11-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"
- 12-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.257" and c/sink (20 holes) as per Dwg D3391
- 13-Open .375" holes to .438" \*\*\*do not open fwd saddle holes\*\*\*
- 14-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)
- 15- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021
- 16- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.
- 17- Locating from two fwd wearplate holes drilol remaining 6 wearplte holes in D3391-021 using DT8937
- 18- Open 2 fwd wearplate holes in D3391-023 to .250" dia.
- 19- Open 12 wearplate holes in D3391-021 to 0.257" dia.
- 20-Deburr and blow out all chips from inside tube

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*7-5-25*

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*5b 7-5-29*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 5/7/2007 3:26:13 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 32237

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*Am 5-29-07*



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEB

Pick:

Qty

Part Number

Description

Batch

1

D3389-1

Web

*B32291*

A/R

Sikaflex-241/-291

*m 103561*

Sikaflex expire date:

*7-10-1*

Start: *10:30* Time: *7-5-29*

Finish: *2:30* Time: *7:20 AM*

*5075-29*

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

2-Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

*5075-29*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Am 5-30-07*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*BR/m/07-07-19*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL 07/07/23*

12.0

NAS1330C3KB116

Insert



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Insert

Pick:

Qty

Part Number

Description

Batch

20

NAS1330C3KB116

Insert

*M100712*

*AL0201-03*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: 7 Date: 07/08/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 5/7/2007 3:26:13 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 32237

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

NAS1330C3KB166

INSERT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

RivnuT

Pick:

Qty Part Number

Description

Batch

10

NAS1330C3KB166

Insert

M 102849 M1

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install inserts as per dwg D3391

touch-up holes in D3391-021 with alodine

28 0707-23 ①

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect each insert using DT8821

En 0707/23 ①

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

33525A

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

28 0708/22 ①

Job Completion



U 0708.22

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

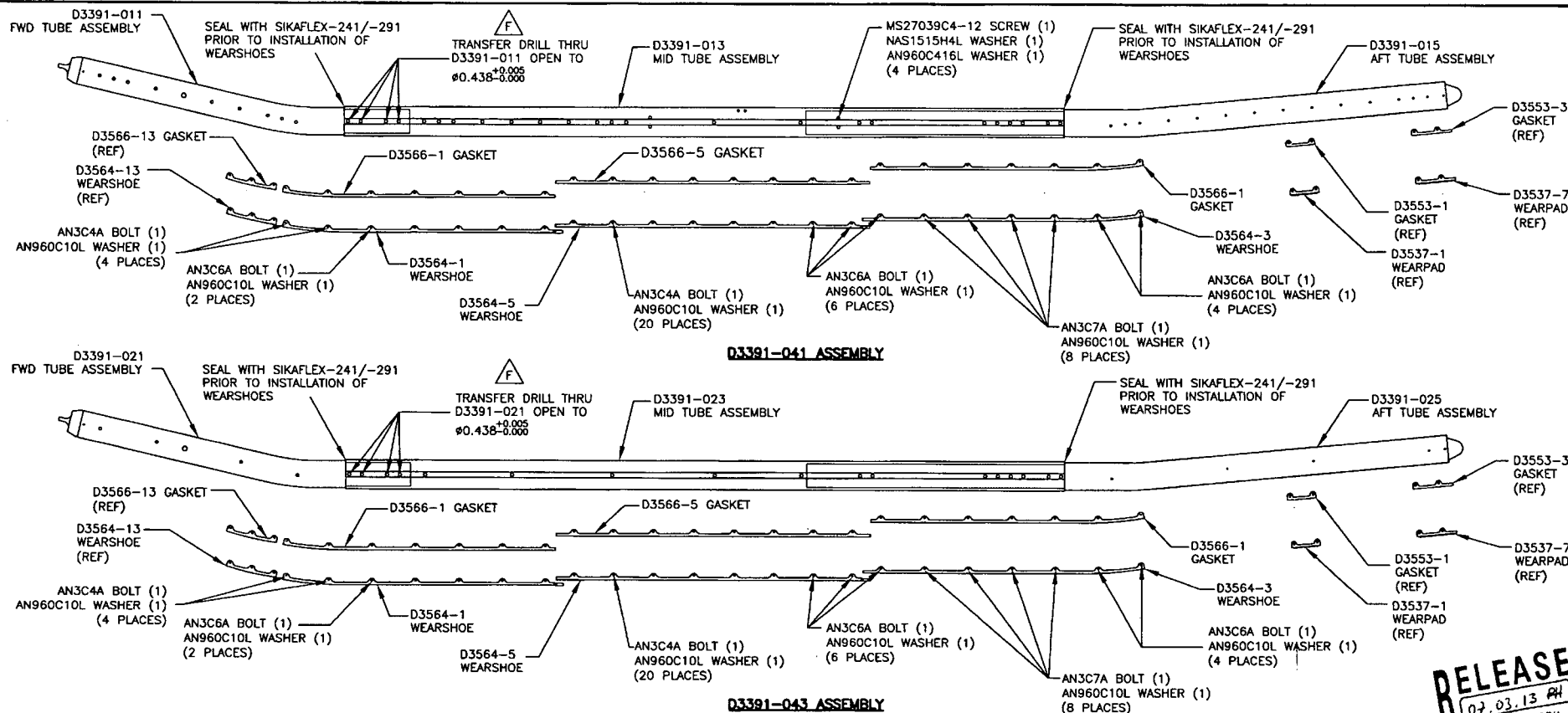
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries





#### D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

| QTY  | QTY  | PART NUMBER  | DESCRIPTION             |
|------|------|--------------|-------------------------|
| -041 | -043 |              |                         |
| X    | X    | D3391-041    | FLOAT SKIDTUBE ASSEMBLY |
|      |      | D3391-043    | FLOAT SKIDTUBE ASSEMBLY |
| 1    |      | D3391-011    | FWD TUBE ASSEMBLY       |
| 1    |      | D3391-013    | MID TUBE ASSEMBLY       |
| 1    |      | D3391-015    | AFT TUBE ASSEMBLY       |
| 1    | 1    | D3391-021    | FWD TUBE ASSEMBLY       |
| 1    | 1    | D3391-023    | MID TUBE ASSEMBLY       |
| 1    | 1    | D3391-025    | AFT TUBE ASSEMBLY       |
| 1    | 1    | D3564-1      | WEARSHOE                |
| 1    | 1    | D3564-3      | WEARSHOE                |
| 2    | 2    | D3566-1      | GASKET                  |
| 1    | 1    | D3566-5      | GASKET                  |
| 24   | 24   | AN3C4A       | BOLT                    |
| 12   | 12   | AN3C6A       | BOLT                    |
| 8    | 8    | AN3C7A       | BOLT                    |
| 44   | 44   | AN960C10L    | WASHER                  |
| 4    | 4    | MS27039C4-12 | SCREW                   |
| 4    | 4    | NAS1515H4L   | WASHER                  |
| 4    | 4    | AN960C416L   | WASHER                  |

#### GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL/TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C'SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

WORK ORDER  
32237  
ENGINEERING  
CONTROLLED COPY  
RETURN TO  
SHOP COPY

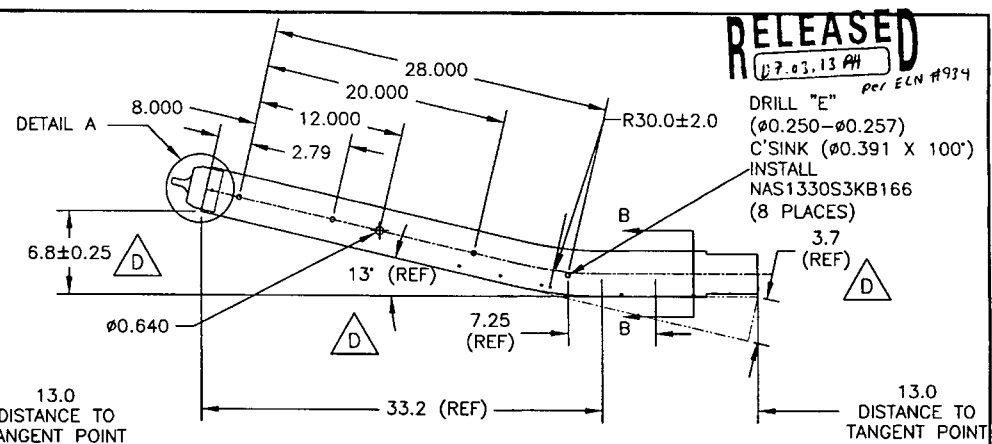
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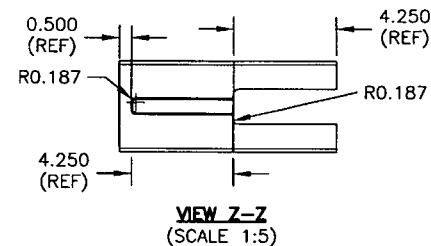
|                   |                             |   |
|-------------------|-----------------------------|---|
| F                 | 07.01.18                    | ADD SS WEARSHOE, GASKET<br>REMOVE FWD SADDLE HOLE -011/-021 |
| E                 | 06.04.25                    | CHANGE TOLERANCE, EASE MANUFACTURE                          |
| D                 | 06.01.23                    | UPDATE TOLERANCE, CHANGE HOLE SIZE                          |
| C                 | 05.09.27                    | LENGTHEN AFT EXTENSION                                      |
| B                 | 05.06.10                    | DRAWING UPDATES   |
| A                 | 05.02.07                    | NEW ISSUE   |
| DESIGN            | DRAWN BY                    | <b>DART</b> DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA    |
| CHECKED <i>PH</i> | APPROVED <i>PH</i>          | DRAWING NO.<br>D3391  |
| DATE<br>07.01.18  | TITLE<br>412 FLOAT SKIDTUBE | REV. F<br>SHEET 1 OF 5<br>SCALE<br>NTS                      |

RELEASED  
07.03.13 PH  
per E-N #934

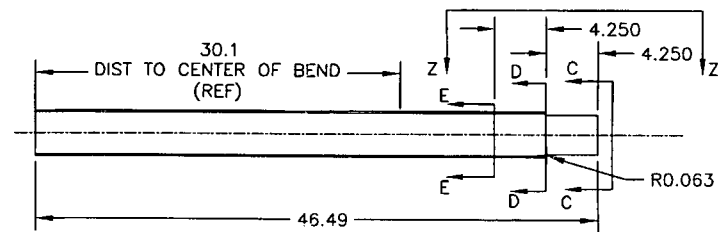
DRILL "E"  
( $\phi 0.250 - \phi 0.257$ )  
C'SINK ( $\phi 0.391 \times 100'$ )  
INSTALL  
NAS1330S3KB166  
(8 PLACES)



**D3391-021 ASSEMBLY AND BENDING DETAIL**



**VIEW Z-Z**  
(SCALE 1:5)



**D3391-1 DRILLING AND CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

| <b><u>D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST</u></b> |                  |                    |                            |
|---|------------------|--------------------|----------------------------|
| <b>QTY - 011</b>  | <b>QTY - 021</b> | <b>PART NUMBER</b> | <b>DESCRIPTION</b>         |
| X   |                  | D3391-011          | FWD TUBE ASSEMBLY          |
|   | X                | D3391-021          | FWD TUBE ASSEMBLY          |
| 1   | 1                | D6013-047          | FWD TUBE                   |
| 1   | 1                | D3401-041          | TOW CAP                    |
| 1   | 1                | D3564-13           | WEARSHOE                   |
| 1   | 1                | D3566-13           | GASKET                     |
| 10  | 10               | AN3C4A             | BOLT                       |
| 4   | 4                | NAS1515H3L         | WASHER                     |
| 10  | 10               | AN960C10L          | WASHER                     |
| 30  | 20               | NAS1330S3KB166     | INSERT (OR NAS1330C3KB166) |

5

(0.25)  
(0.39)

C'SINK


NAS133

(1)

SHOP COPY  
RETURN TO  
ENGINEERING

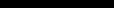


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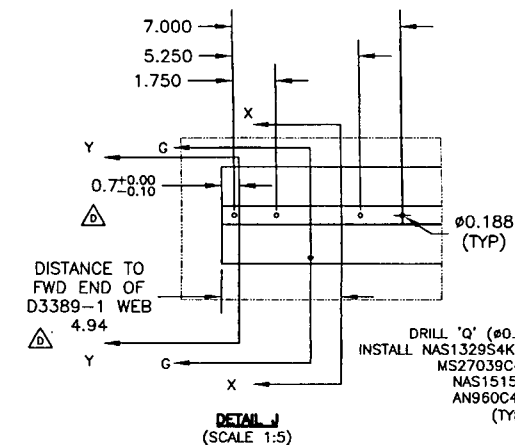
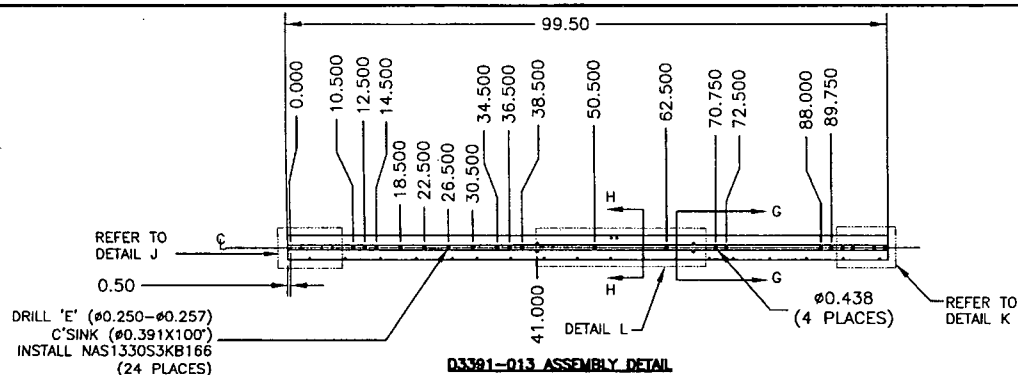
WORK ORDER  
NO. 32237


 DRILL "E"  
 (Ø0.250-Ø0.257)  
 C'SINK (Ø0.391 X 100")  
 INSTALL  
 NAS1330S3KB166  
 (12 PLACES)

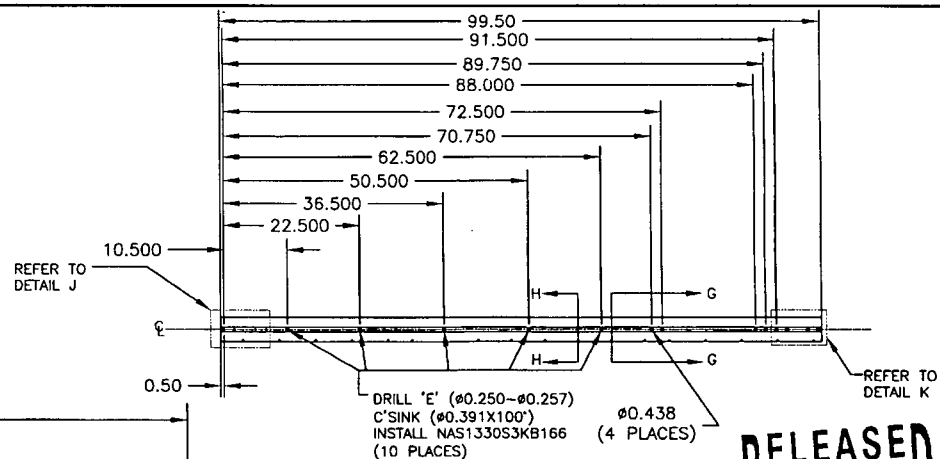
**SECTION B-B**  
(SCALE 1:5)

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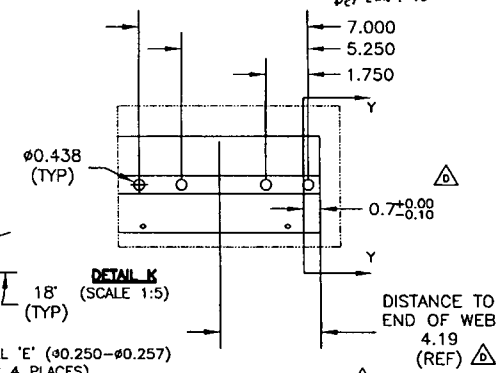
|   |  |   |              |
|---|--|---|--------------|
| DESIGN  | DRAWN BY   |  <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA |              |
| CHECKED  | APPROVED  | DRAWING NO.   | REV. F       |
|   |  | D3391   | SHEET 2 OF 5 |
| DATE  | TITLE  |   | SCALE        |
| 07.01.18  | 412 FLOAT SKIDTUBE   |   | 1:10         |



DRILL 'Q' (#0.332-#0.338)  
INSTALL NAS1329S4KB140 INSERT  
MS27039C4-08 SCREW  
NAS1515H4L WASHER  
AN960C416L WASHER  
(TYP 4 PLACES)



**D3391-023 ASSEMBLY DETAIL**



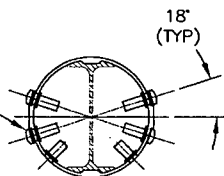
**D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST**

| QTY - 013 | QTY - 023 | PART NUMBER    | DESCRIPTION                |
|-----------|-----------|----------------|----------------------------|
| X         |           | D3391-013      | MID TUBE ASSEMBLY          |
|           | X         | D3391-023      | MID TUBE ASSEMBLY          |
| 1         | 1         | D2500-1-100    | EXTRUSION                  |
| 1         | 1         | D3389-1        | WEB                        |
| 24        | 20        | NAS1330S3KB116 | INSERT (OR NAS1330C3KB116) |
| 24        | 10        | NAS1330S3KB166 | INSERT (OR NAS1330C3KB166) |
| 4         |           | NAS1329S4KB140 | INSERT (OR NAS1329C3KB140) |
| 4         |           | NAS1515H3L     | WASHER                     |
| 4         |           | AN960C10L      | WASHER                     |
| 4         |           | NAS1515H4L     | WASHER                     |
| 4         |           | AN960C416L     | WASHER                     |
| 4         |           | MS27039C1-09   | SCREW                      |
| 4         |           | MS27039C4-08   | SCREW                      |

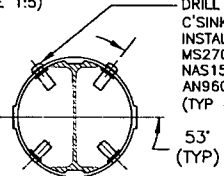
**D3391-013/-023 MID TUBE ASSEMBLY**

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

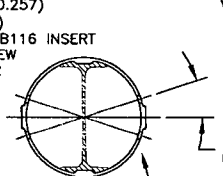
**SECTION L-L**  
(SCALE 1:4)



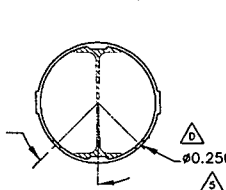
**SECTION M-M**  
(SCALE 1:4)



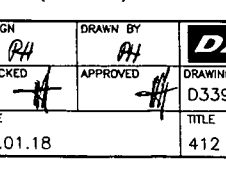
**SECTION LL-LL**  
(SCALE 1:4)



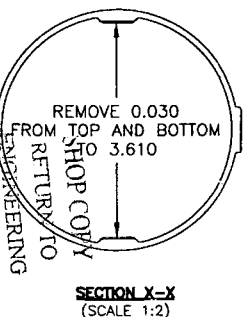
**SECTION Y-Y**  
(SCALE 1:4)



**SECTION G-G**  
(SCALE 1:4)

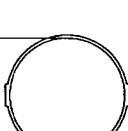


**SECTION H-H**  
(SCALE 1:4)

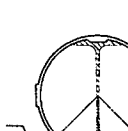


**SECTION X-X**  
(SCALE 1:2)

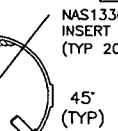
REMOVE 0.225  
FROM TOP AND BOTTOM  
TO 3.800  
(0.7 FROM BOTH ENDS)



**SECTION Y-Y**  
(SCALE 1:4)



**SECTION G-G**  
(SCALE 1:4)

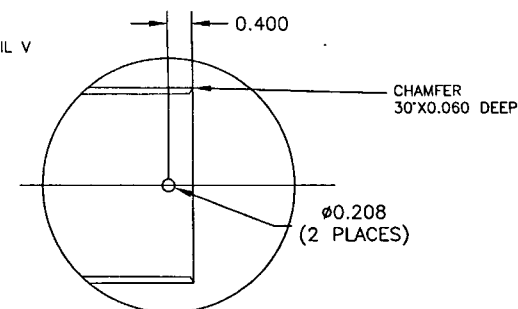
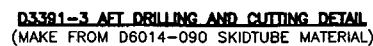
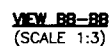


**SECTION H-H**  
(SCALE 1:4)

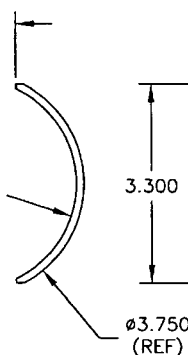
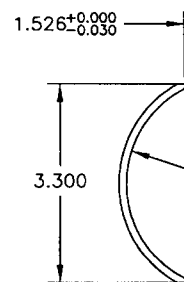
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| CHECKED<br>H                                 | APPROVED<br>H | DRAWING NO.<br>D3391        |                | SHEET 3 OF 5   |        |
| DATE<br>07.01.18                             |               | TITLE<br>412 FLOAT SKIDTUBE |                | SCALE<br>1:20  |        |

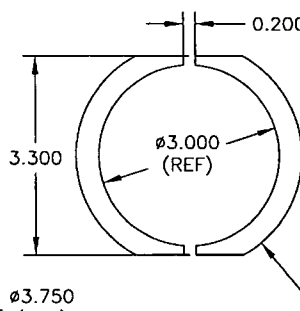
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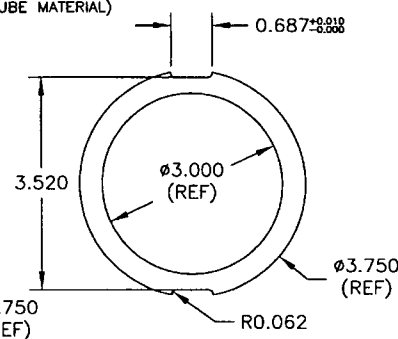
**DETAIL V**  
(SCALE 1:2)



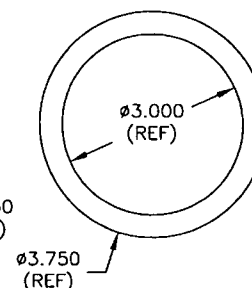
**SECTION N-N**  
(SCALE 1:2)



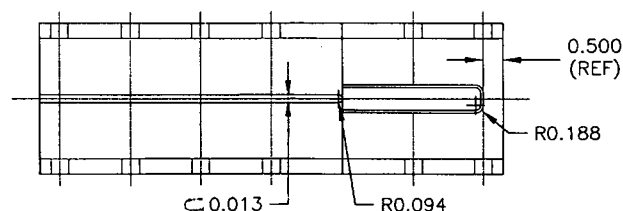
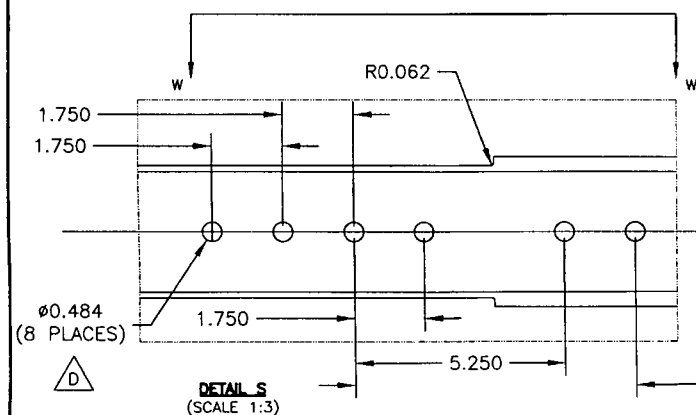
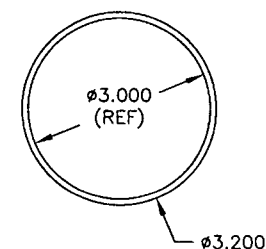
**SECTION P-P**  
(SCALE 1:2)



**SECTION 0-0**  
(SCALE 1:2)



**SECTION R-R**  
(SCALE 1:2)



**VIEW W-W**  
(SCALE 1:3)

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| DATE<br>07.01.18  | TITLE<br>412 FLOAT SKIDTUBE |   | SCALE<br>1:12          |

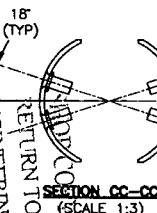
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PER ECU #934

0.013  
VIEW W-  
(SCALE 1  
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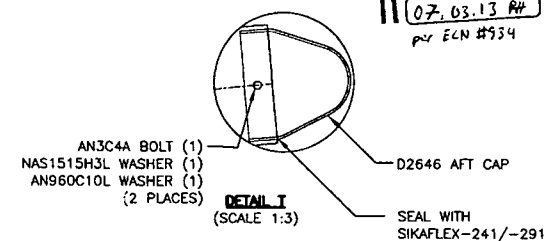
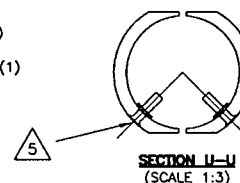


| QTY - 015 | QTY - 025 | PART NUMBER    | DESCRIPTION                |
|-----------|-----------|----------------|----------------------------|
| X         |           | D3391-015      | AFT TUBE ASSEMBLY          |
|           | X         | D3391-025      | AFT TUBE ASSEMBLY          |
| 1         | 1         | D6014-090      | AFT TUBE                   |
| 1         | 1         | D2646          | AFT CAP                    |
| 1         | 1         | D3537-1        | WEARPAD                    |
| 1         | 1         | D3537-7        | WEARPAD                    |
| 1         | 1         | D3553-1        | GASKET                     |
| 1         | 1         | D3553-3        | GASKET                     |
| 18        | 14        | NAS1330S3KB366 | INSERT (OR AES10KB366)     |
| 4         | 2         | NAS1330S3KB316 | INSERT (OR NAS1330C3KB316) |
| 8         | 6         | NAS1330S3KB266 | INSERT (OR NAS1330C3KB266) |
| 4         |           | NAS1330S3KB216 | INSERT (OR NAS1330C3KB216) |
| 16        | 12        | NAS1330S3KB166 | INSERT (OR NAS1330C3KB166) |
| 4         |           | NAS1330S4KB151 | INSERT (OR NAS1330C4KB151) |
| 6         | 6         | AN3CAA         | BOLT                       |
| 4         | 4         | AN3CSA         | BOLT                       |
| 2         | 2         | AN5151SH3L     | WASHER                     |
| 10        | 10        | AN660C10L      | WASHER                     |

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DRILL 'Q' (ø0.332-ø0.338)  
C'SINK (ø0.529X100°)  
NAS1330S4KB151 INSERT (1)  
(4 PLACES)



C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

| HOLES MARKED | QTY D3391-015 | QTY D3391-025 | C'SINK | P/N            |
|--------------|---------------|---------------|--------|----------------|
| CS1          | 18            | 14            | Ø0.425 | NAS1330S3KB366 |
| CS2          | 4             |               | Ø0.391 | NAS1330S3KB366 |
| CS3          | 4             | 2             | Ø0.391 | NAS1330S3KB316 |
| CS4          | 8             | 6             | Ø0.391 | NAS1330S3KB266 |
| CS5          | 4             |               | Ø0.391 | NAS1330S3KB216 |
| CS6          | 16            | 12            | Ø0.391 | NAS1330S3KB166 |

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|  |               |
|--|---------------|
|  | <b>DESIGN</b> |
|--|---------------|

DRAWN BY

CHECKE

APPROVED

DATE:

07.01.18

|          |             |
|----------|-------------|
| APPROVED | DRAWING NO. |
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|--|-------|
|  | 03391 |
|--|-------|

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412 FLOAT SKIDTUBE

**DART** DART AEROSPACE USA, INC.  
PORT HADLOCK, WA

REV. F

REV. F

SHEET 5 OF 5

SCALE

1:12

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